

Work Order ID 70073

Thursday, May 26, 2011 10:33:17 AM

Page 1

Item ID: D3643-2

Accept

Revision ID:

Item Name: Stiffener

Start Date: 5/26/2011 Start Qty: 6.00

Required Date: 6/3/2011 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 5-26-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3643

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3643 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

2024.040

B11-5-26

8

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-5-26

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sulaska

28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70073

Thursday, May 26, 2011 10:33:18 AM



Page 2

Item ID: D3643-2

Accept



Setup Start



Revision ID:

Item Name: Stiffener

Stop



Start Date: 5/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Form as per Dwg D3643

SB 11/05/27

8

140



Small Fab

Small Fab

0.00

Memo

0.00

C'sink as per Dwg D3643

SB 4/05/27 8

150



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

SB 11/05/30

8

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

Work Order ID 70073

Thursday, May 26, 2011 10:33:18 AM

Page 3

Item ID: D3643-2

Accept

Revision ID:

Item Name: Stiffener

Start Date: 5/26/2011 Start Qty: 6.00

Required Date: 6/3/2011 Req'd Qty: 6.00

Reference:

Cust Item ID:




Customer:

Approvals: / Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00				8	0	BR	11-5-30.
Hand Finishing	Memo	0.00							
170  QC	QC3- Inspect Part Finish	0.00				8	4	N	11/05/30
Quality Control	Memo	0.00							
180  Packaging	Identify as per dwg & Stock Location: 244A	0.00							
Packaging	Memo	0.00							11/5/30 825P

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70073

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Thursday, May 26, 2011 10:33:18 AM

Item ID:	D3643-2	Accept		Setup	Start	
Revision ID:						
Item Name:	Stiffener			Stop		
Start Date:	5/26/2011	Start Qty: 6.00				
Required Date:	6/3/2011	Req'd Qty: 6.00				
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							11/5/31

11-05-31
(8)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 26, 2011 10:33:36 AM

Page 1

Work Order ID: 70073



Parent Item: D3643-2



Parent Item Name: Stiffener


Start Date: 5/26/2011

Required Date: 6/3/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040  2024-T3 .040 sheet		Purchased	No			100	sf	234.9000	0.1475	0.931579	2.5		



FB H-5-26

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT022	234.9	
112291	0.5	
112331	0.7	
113162	41.7	
117684	192	

113162

8

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	70063
Description: Stiffener		Part Number:	D3643-2
Inspection Dwg: D3643	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.100	✓		V 1302	
Ø0.266	+0.006/-0.001	.266	2		V	
1.90	+/-0.030	1.908	2		V	
0.96	+/-0.030	.962	✓		V	
1.25	+/-0.030	1.249	✓		V	
2.000	+/-0.010	2.001	2		V	
4.49	+/-0.030	4.487	>		V	
9.00	+/-0.030	9.002	2		P ROWS02	
9.75	+/-0.030	9.751	✓		P	
0.81	+/-0.030	.808	✓		V	
0.040	+/-0.010	.042	2		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-5-20	Date: 11/05/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	AS

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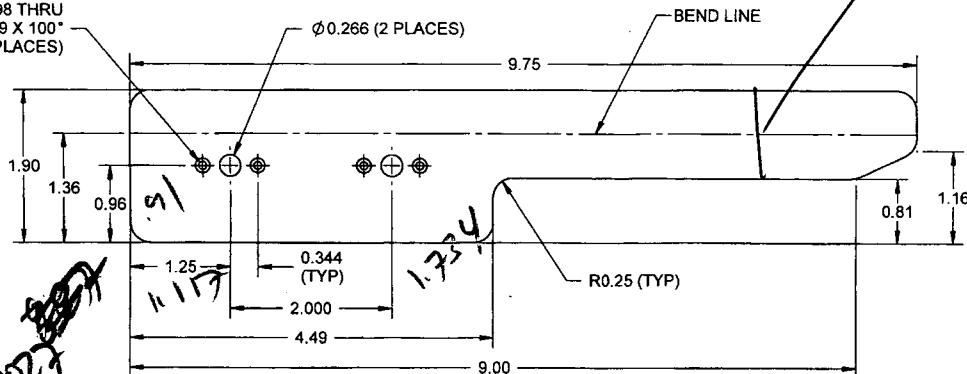
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Ø0.098 THRU
C'SINK Ø0.179 X 100°
(4 PLACES)

GRAIN
DIRECTION

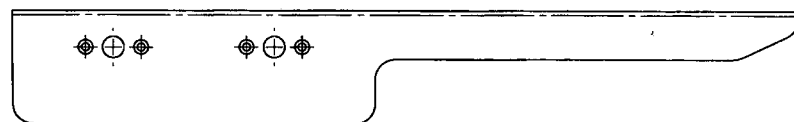


**D3643-1F FLAT PATTERN
(D3643-2F OPPOSITE)**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70073

11-05-21

ENSURE THAT COUNTERSINKS
ARE ON THIS SIDE OF THE PART



**D3643-1 STIFFENER (REPLACES GENEVA P/N G10610-2)
D3643-2 OPPOSITE (REPLACES GENEVA P/N G10610-1)**

RELEASED
07.09.07

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3643-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

A	NEW ISSUE; REPLACES G10610	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CE		
CHECKED	EB	DRAWING NO.	REV. A
MFG. APPR.	EB	D3643	SHEET 1 OF 1
APPROVED	EB	TITLE	SCALE
DE APPR.	EB	STIFFENER	2:3
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES						
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